

Work Order ID 52923

October 19, 2009 10:56:45 AM

Page 1

Item ID: D3956-3

Accept

Revision ID: A

Item Name: Hinge, Airframe Lower

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 8.00

Required Date: 11/02/09 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *09/10-19* Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3956

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3956

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

= 7 m. of out/col 29

19X

(19)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-10-09

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Page 2

Item ID: D3956-3

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Start Date: 10/19/09 Start Qty: 8.00

Required Date: 11/02/09 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

Start Time: 12:00
Oven Temperature: 320°
Finish Time: 12:30



(X/S)

(19)

(19)

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Page 3

Item ID: D3956-3

Accept

Revision ID: A

Item Name: Hinge, Airframe Lower

Start Date: 10/19/09 Start Qty: 8.00

Required Date: 11/02/09 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MD 09/11/02

X19

160

Identify as per dwg & Stock Location: 139

0.00



Packaging

Memo

0.00

Packaging

09/11/3

(19)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/03

NF 09-11-03

Picklist Print

October 19, 2009 10:56:48 AM

Page 1

Work Order ID: 52923

Parent Item: D3956-3A-PRELIM

Parent Item Name: Hinge, Airframe Lower

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased	No			100	sf	29.5500	1.3457			



6061T6 SHEET .250



189-10-29

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

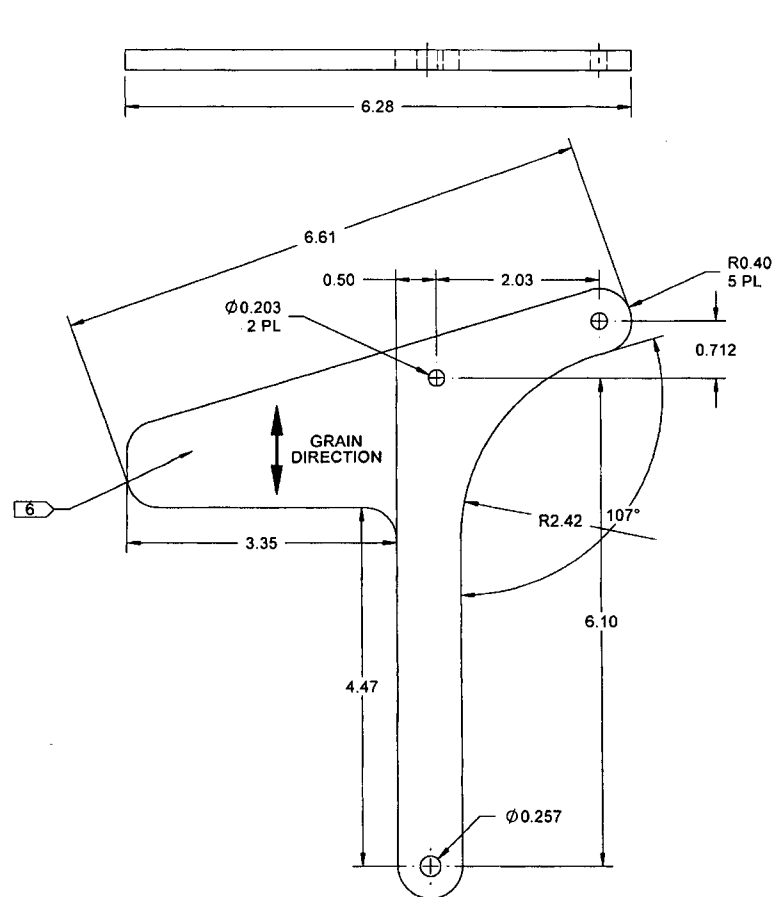
MAT

29.55

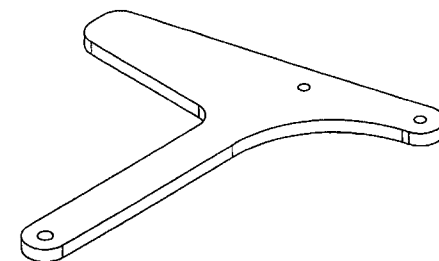
112663

29.55

112663



D3956-1 HINGE, AIRFRAME UPPER



SHOWN
REV.
ENGIN
UNCONTROLLED
SUBJECT
WITH
WO:
NO. 52923
PL 09-10-15

RELEASED
2009-10-08
JMT

NOTES:

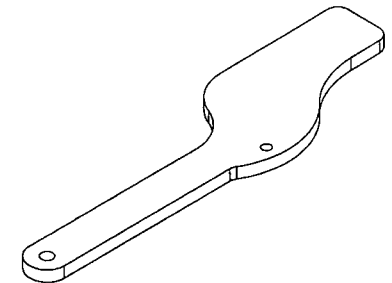
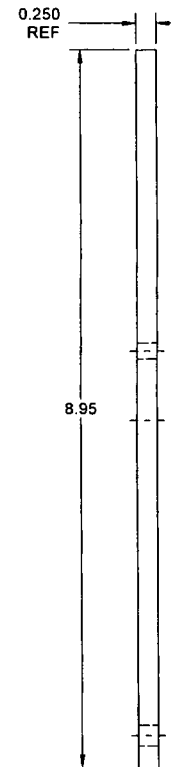
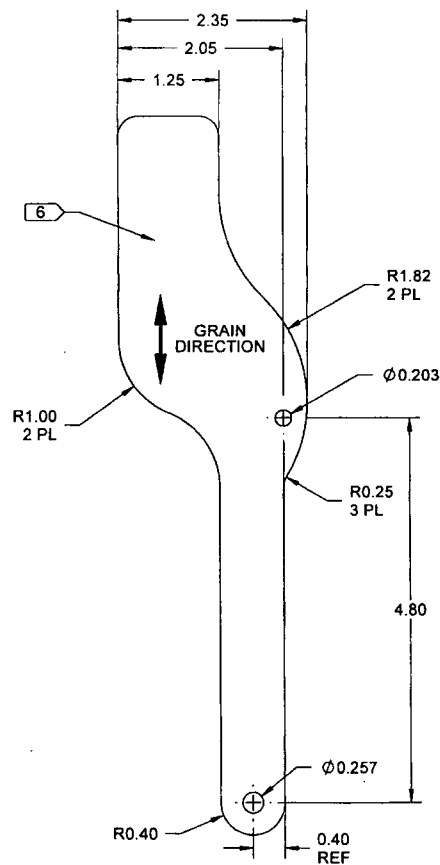
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3956-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.09.14			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3956
REV. A
SHEET 1 OF 2
TITLE HINGE
SCALE NTS

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WITHOUT NOTICE
WORK ORDER
NO. 52923

RELEASED
2009-10-08
NH

D3956-3 HINGE, AIRFRAME LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3956-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3956	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.09.14	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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